

Work Order ID 50139

July 8, 2009 1:42:37 PM



Page 1

Item ID: D3574-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cabin Floor Protector

Start Date: 07/08/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/14/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *09-07-08*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 ☐ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-
Deburr if necessary

B 9-9-8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-9-8

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 8/10/08

(X) 8

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Item Name: Cabin Floor Protector

Start Date: 07/08/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/14/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Packaging	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							

9/09/08 (4)

=> 8/02/08

(XY) /

9/9/9 (4xSp)

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Start Date: 07/08/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/14/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/09 *[Signature]*
PL 09-9-09 (4)

Picklist Print

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Page 1

Work Order ID: 50139

Parent Item: D3574-1RevB

Parent Item Name: Cabin Floor Protector

Comments:

Start Date: 07/08/2009

Required Date: 07/14/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	1,278.050	134.4672			



GE PLASTICS LEXAN SHEET



B 9-9-8

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	1278.05	
103106	7.8	
105330	54	
109455	0.03	
111710	1216.22	
112585		

112585

DART AEROSPACE LTD		Work Order: 50139
Description: Cabin Floor Protector		Part Number: D3574-1
Inspection Dwg: D3574	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	X			
7.37	+/-0.030	7.37	X			
10.75	+/-0.030	10.75	X			
11.00	+/-0.030	11.00	X			
15.25	+/-0.030	15.25	X			
25.87	+/-0.030	25.87	X			
39.75	+/-0.030	39.75	X			
44.75	+/-0.030	44.75	X			
49.11	+/-0.030	49.11	X			
51.11	+/-0.030	51.11	X			
53.51	+/-0.030	53.51	X			
63.50	+/-0.030	63.50	X			
65.25	+/-0.030	65.25	X			
10.75	+/-0.030	10.75	X			
11.06	+/-0.030	11.06	X			
14.75	+/-0.030	14.75	X			
25.50	+/-0.030	25.50	X			
25.75	+/-0.030	25.75	X			
26.00	+/-0.030	26.00	X			
32.87	+/-0.030	32.87	X			
38.81	+/-0.030	38.81	X			
44.75	+/-0.030	44.75	X			
45.00	+/-0.030	45.00	X			
48.25	+/-0.030	48.25	X			
58.38	+/-0.030	58.38	X			
61.25	+/-0.030	61.25	X			
64.13	+/-0.030	64.13	X			
64.63	+/-0.030	64.63	X			
66.50	+/-0.030	66.50	X			
7.50	+/-0.030	7.50	X			
9.50	+/-0.030	9.50	X			
10.38	+/-0.030	10.38	X			
10.88	+/-0.030	10.88	X			
14.50	+/-0.030	14.50	X			

DART AEROSPACE LTD		Work Order:	50139
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574	Rev: B	Page 2 of 2	

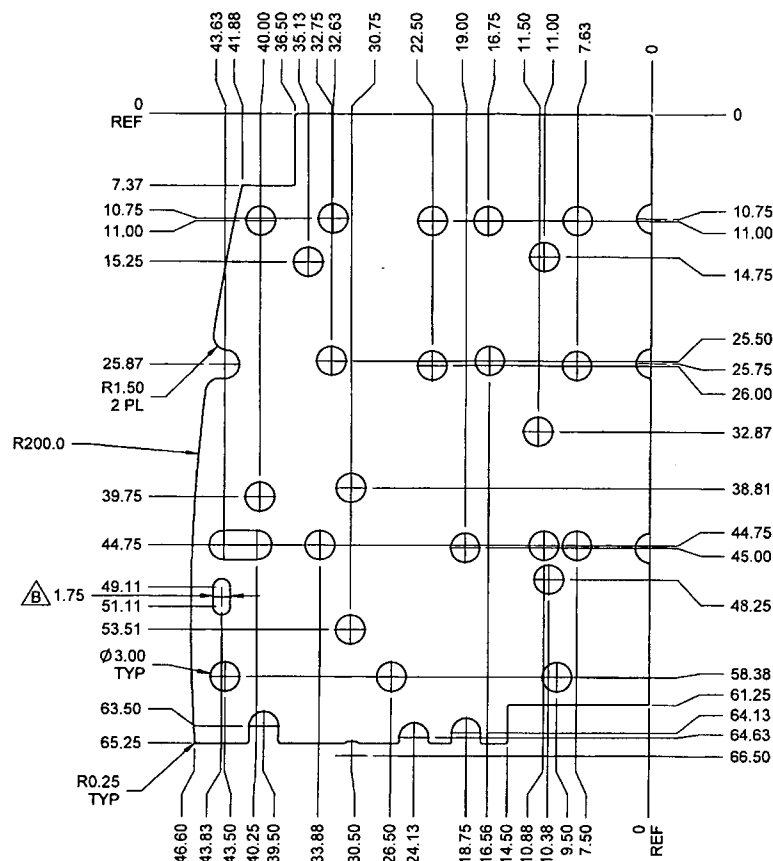
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

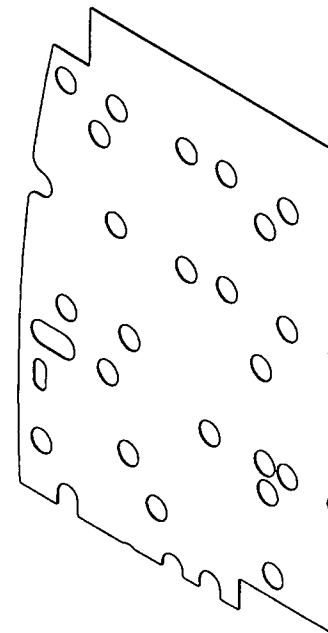
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	16.56	*			
18.75	+/-0.030	18.75	*			
24.13	+/-0.030	24.13	*			
26.50	+/-0.030	26.50	*			
30.50	+/-0.030	30.50	*			
33.88	+/-0.030	33.88	*			
39.50	+/-0.030	39.50	*			
40.25	+/-0.030	40.50	*			
43.50	+/-0.030	43.50	*			
43.83	+/-0.030	43.83	*			
46.60	+/-0.030	46.60	*			
7.63	+/-0.030	7.63	*			
11.00	+/-0.030	11.00	*			
11.50	+/-0.030	11.50	*			
16.75	+/-0.030	16.75	*			
19.00	+/-0.030	19.00	*			
22.50	+/-0.030	22.50	*			
30.75	+/-0.030	30.75	*			
32.63	+/-0.030	32.63	*			
32.75	+/-0.030	32.75	*			
35.13	+/-0.030	35.13	*			
36.50	+/-0.030	36.50	*			
40.00	+/-0.030	40.00	*			
41.88	+/-0.030	41.88	*			
43.63	+/-0.030	43.63	*			
0.125	+/-0.010	.124	>			

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 9-9-8	Date: 09/09/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	



REFERENCE ONLY



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

B	ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5, -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

RELEASED
09/04/07

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3574
REV. B
SHEET 1 OF 6
TITLE
CABIN FLOOR PROTECTOR
SCALE
NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries